

Work Order ID 130295

Wednesday, March 04, 2015 8:49:41 AM

ASAP

130295

Page 1

Item ID: D5041-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Scuff Guard
 Start Date: 3/4/2015 Start Qty: 32.00 *32* Cust Item ID:
 Required Date: 3/4/2015 Req'd Qty: 32.00 *32* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-03-04 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D5041	A								
100		0.00							
100									
Waterjet									
FLOW CNC Waterjet									
304 24 GA.									
	Memo	0.00							
	1-Cut as per Dwg								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110		0.00							
110									
QC									
Quality Control									
	Memo	0.00							
	QC2- Inspect parts off machine FAI/FAIB								
120		0.00							
120									
QC									
Quality Control									
	Memo	0.00							
	QC8- Inspect parts - second check								

12 (38)
26 Ø Jm 15-3-5
12/03/08

12 (38)
26 Ø Jm 15-3-5
12/03/08

(38) Ø DAS
38
9-89
MAR 11 9 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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N900040100

Setup Start *NS1*

Stop *NS2*

32

32

Reference:

Run Start *NR1*

Stop *NR2*

Insp.
Stamm

130

0.00

**DAS
30
9-89**

38

15/03/09

0.00

140

Memo

Quality Control

0.00

(35)

DAS
38

MAR 09 2015

Identify as per dwg & Stock Location: 5H43 0.00

150

Packaging

Packaging

0.00

38

MAR 10 2015

DAG
06
8-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 15-03-10

15-3-10

Picklist Print

Wednesday, March 04, 2015 8:49:45 AM

Page 1

Work Order ID: 130295

130295

Parent Item: D5041-1

D5041-1

Parent Item Name: Scuff Guard

Start Date: 3/4/2015

Required Date: 3/4/2015

Start Qty: 32.00

Required Qty: 32.00

Comments: IPP REV:A 14.05.26 NEW ISSUE/ECN14-567 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S24GA		Purchased			No		sf	30.6660		6			

M304S24GA

304/316 .025 Sheet

Jm15-3.5.

Location

Loc Qty

Loc Code

MAT020

30.666

m129845

30.666

129845

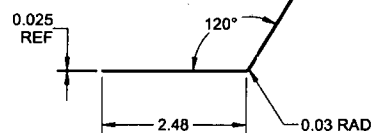
~~3.89~~
~~3.89~~ FT.

131723

5.4

OK 15/03/08

130295 MCL
1503-04



D5041-1 SCUFF GUARD

NOTES:

- 1) MATERIAL: MADE FROM D5041-1F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.18 lbs

RELEASED
2014-05-26

A	NEW ISSUE	AK	14.01.15
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE USA, INC.	
DRAWN	AK	KENT, WA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5041	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	SCUFF GUARD	NTS
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APPROVED



7) WEIGHT: 0.18 lbs

APPROVED	DESIGN	AK	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AK		
	CHECKED	VS	DRAWING NO.	REV. A
	MFG. APPR.	JLM	D5041	SHEET 2 OF 2
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